<b>Work Orde</b> November-27-12				*938			Page				
Revision ID:	D2174-041 Web, 205			Accept	*N900	<b>040</b>	100	)* s	etup Start Stop		S1* S2*
Start Date: Required Date: Reference:	11/22/12 12/14/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:			0.		
Approvals:	Process Plan: MLゴ		Date: 12-11-2	28 Tooling:	Date:			R	tun Start	"17	R1*
	QC:		Date:	SPC (Y/N):	Da			Stop	*N	R2*	
Sequence ID/ Work Center II	Operation Description		· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr									-
D2174	Rev	E									1
*100 *100* Small Fab Small Fab		Small Fab  Memo	e as per Dwg D2174-0412	0.00 0.00 2- Identify as D2174-041				4			X,
110 *110* QC Quality Control		QC5- Inspect part comp		0.00 \$5 0.00	16			4			
120 *120* Powdercoat		White Gloss Regid So	per QSI005 4.3-Alum	0.00				4	ф_	IX 1	13-1-16,

Powder Coating

$\neg$
or
t

#### **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Crushed/Crimped. Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Misread Power Loss/Surge Other Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

Setup
Other
Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Orde</b> November-27-12			*93840*							Page 2
Revision ID:	D2174-041 Web, 205			Accept	*N900	<b>0401</b>	იი*	Setup	Start Stop	*NS1* *NS2*
	11/22/12 12/14/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:				14(1)
Approvals:	Process Pla	an:	Date:			nte:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool# P	lan Acco	ept Re Qt	-	Reject Insp. Number Stamp
*140 *140* Small Fab Small Fab		Small Fab <b>Memo</b> Install nuts &	bolts loosely as per Dwg	0.00 0.00 g D2274				tx_		JS:3
150 *150* QC		QC5- Inspect part comple	teness to step on W/O	0.00	)AS 15 17		4			· · · · · · · · · · · · · · · · · · ·

Quality Control

									DQA:	Date:
NCR: Yes	/ No				WORK ORDER NON-	JPDATE	QA Closed:	Date:		
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS
				<del></del>	Rework	1	Skid-tube	Crosstube		Water Jet
Part No.					Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.
					Use-as-is	Therr	moforming	Finishing	Rec/Sto	re/Packaging
NCR No.	·				Work Order Update		Large Fab	Composite		Supplier
Root				Descri	ption of work order update	Initial		Action	Sign &	
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	De	escription	Date	Verification

Engineering Quality Other

QC Inspector

#### Unapproved **FAULT CATEGORY Landing Gear** General Bend Bending Grain Ovalized Pressure/Forced BOM/Route Centre Not Concentric to O/S Hardware Temperature/Cure Over/Under tolerance Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Other Cut Too Short Misread Power Loss/Surge Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

**Outside Dimensions** 

Wave/Twist in Tube

Folio

Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde				*938	340*				Page 3
Item ID: Revision ID: Item Name:	D2174-041 Web, 205		,	Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	11/22/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				IV.57
Approvals:	Process Plan:QC:		Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* Packaging	<b>D</b>	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Ac Code Qt		-	Reject Insp. Number Stamp
Packaging  170 *170* QC		QC21- Final Inspection -	Work Order Release	0.00					3/01/22 &

Quality Control

pl13-01-21

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
									·	QA Closed:	Date:	·-····································
Work Orde	r:		· · · · · · · · · · · · · · · · · · ·		DISPOSITION			_	AGAINST DE	PARTMENT	PROCESS	
Part N	o				Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	l .	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update	]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	otion of work order update	Ini	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator [		ł										
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved		<u> </u>			<u> </u>				*			
					, <u>F</u>	AULT	CATE	GORY				
Landin	ig Gear				General	_				_		-
[	Bending			L	Bend		Grain			Ovalized		Pressure/Forced
1	Centre No	ot Concer	ntric to C	)/s	BOM/Route	Шн	lardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	L Ir	nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/0	Crimped.			Burrs	∐ lr	nstructi	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[	Cuffs				Contamination		√lainte	nance		Part Moved		_
	Heat Trea	t			Countersink	$\square$	∕Iislabe	led		Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short		∕lisread	I		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes	c	Offset					
	Torque W	aves in E	xtrusion		Drawing	Out of Calibration						
	Turning Sequence				Finish (5)	Out of Sequence						
	Wave/Tw	ist in Tub	oe		Folio **	$\prod$ c	Outside	Dimensions				

Date: \_

DQA:

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# **Picklist Print**

November-27-12 11:48:59 AM

Work Order ID:

93840

Parent Item:

D2174-041

Parent Item Name:

Web, 205

IPP: D04.06.10Reformat; Changed Step 2KJ/JLM

Start Date: 11/22/12

Required Date: 12/14/12

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP: D04.06.10Ref IPP Rev:E As per I			JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C832R14 Screw		Purchased	No			140	Each	354.0000	4	16		13,	01/17
				<b>Location</b>		Loc Qty	Lo	c Code				1	/
				ST346		306				/			
				104	916	306				6			
				ST348		48		×					
,				104	916	48						7/	//
AN960JD8	NAS1149DN832J	Purchased	140	$\mathcal{I}$		140	Each	0.0000	4	16		/)/ 3	6/
Washer	40	123348	(16)	* ]]							11/		
D2174-1		Manufactured	No	9		100	Each	4.0000	1	4	-4/	12/	1/10
Web												3/0	
				<b>Location</b>		Loc Qty	<u>Lo</u>	oc Code					
				GA		4							
				866	558	4				1			,
D2175-1		Manufactured	No			100	Each	6.0000	1	4	ركس		
Angle LH												באג	101 J1
				Location		Loc Qty	<u>L</u> c	oc Code					
				GA		6							
				868	386	6				4			
D2175-2		Manufactured	No			100	Each	6.0000	1	4			, /, /
Angle RH										*******	<u></u> ×		1/0///
				Location		Loc Qty	<u>L</u> c	oc Code					
				GA		6			_	, <u>i      </u>			
				869	927	6			-	7 - /			

DQA:	Date:	
------	-------	--

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

	,		,						QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	0				Rework		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update	Iner	moforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling					•						
Operator						1	1				
Material <sup>*</sup>											·
Setup											
Other					i e						
Process											<i>3</i> *•
Supplier										·	
Training										,	
Unapproved											
					F	AULT CAT	EGORY				
Landin	g Gear				General				_		
	Bending				Bend	Grain			Ovalized		Pressure/Forced
_	Centre No	ot Concer	ntric to (	o/s·	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		tion Incomplete		Part Incorre	_	Weld
Ļ	Crushed/	Crimped.			Burrs	$\vdash$	ctions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
_	Cuffs			ļ	Contamination	<del></del>	tenance		Part Moved		
	Heat Trea			<u> </u>	Countersink	Mislak	eled	<u> </u>	Positioned \		_
ļ.	Inspection Strip in Tube				Cut Too Short	Misre		<u>L</u>	Power Loss,	'Surge	Other
	Ripples in Bend Drill Holes					Offset					
	Torque W			1 <u> </u>	Drawing	$\vdash$	Calibration			·	
	Turning S			<u></u>	Finish	Out of	Sequence				
	Wave/Twist in Tube				Folio		le Dimensions				

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November-27-12 11:48:59 AM

Work Order ID: Parent Item:	93840 D2174-041						Start I	Date: 11/22/12	Required Date: 12/14/12	
Parent Item Name:	Web, 205						Start	<b>Qty:</b> 4.00	Required Qty: 4.00	
MS20470AD4-6 Rivet, Universal Head		Purchased	No		140	Each	3,690.0000	19	76 3/0/1	
			<u>L</u>	ocation	Loc Qty		Loc Code			
			S	Г336	3690					
				117395	16			-	_	
				118927	143			+6	<u>-</u>	
				119109	12				_	
				120142	81				_	
		•		121524	65				_	
				122452	374				_	
				123021	2999				- /////////////////////////////////////	
MS21042L08 Nut		Purchased	No		100	Each	` 700.0000	4	16 3/0/	
			<u>L</u>	<u>ocation</u>	Loc Qty		Loc Code			
	•		. 3	15	9		•			
				122452	9				- Q(()	
			S	T315	500			12**	- 173	
				122814	500				M/OTIGE	
			S	T317	191					

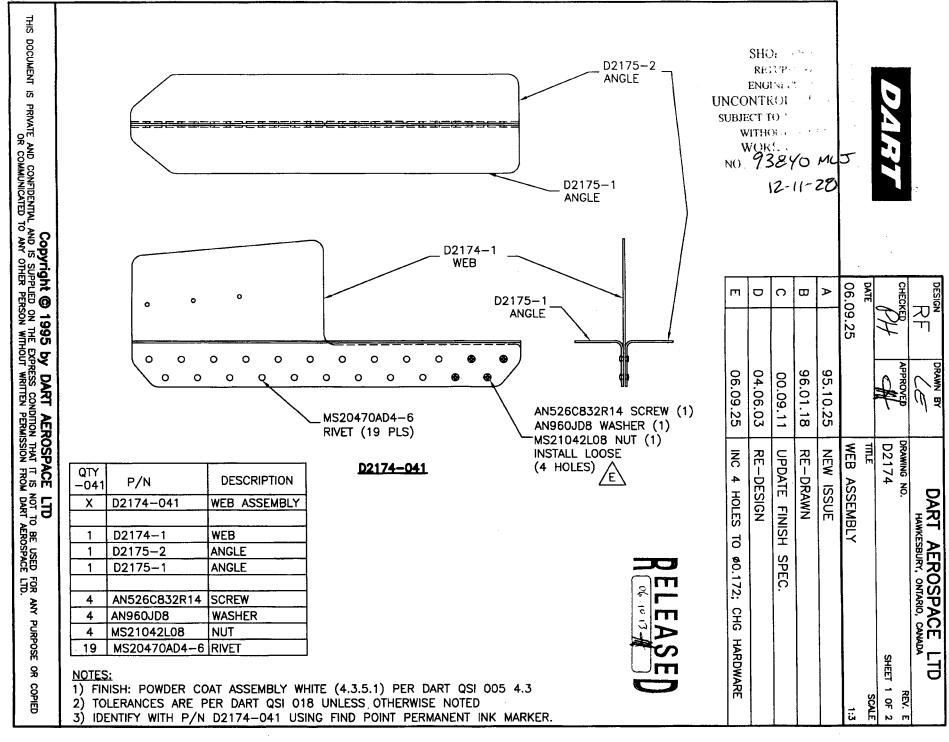
191

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		DQ	A: Date	·
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date	
Work Orde	er:				DISPOSITION			AGAINST DEI	PARTMENT/	PROCESS	
Part N		·			Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &	T. The	Lifeir.
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	iption	Date /	Verification	QC Inspector
Doc/Data Equip/Tooling Operator								/		J.	
Material							:	•		F	
Setup Other	<b>⊢</b>									J	
Process											
Supplier											
Training											
Unapproved											
		<u> </u>	,	······································	F.	AULT CATE	GORY	,		·	·
Landii	ng Gear				General						
	Bending				Bend	Grain	Grain				Pressure/Forced
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorred	et	Weld
	Crushed/	Crimped,			Burrs	Instruc	tions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	Mislabe	eled		Positioned V	Vrong	_
	Inspection Strip in Tube Cut Too Short			Misrea	d		Power Loss/	Surge	Other		
ļ	Ripples in				Drill Holes	Offset					
	Torque Waves in Extrusion Drawing			<b>}</b>	Calibration						
				Finish	<del>  </del>	Sequence					
	Wave/Twist in Tube				Folio	Outside	e Dimensions				

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 RF	CE	UA. ∓
CHECKED,	APPROVED	DRAWING NO.
 F	*	D2174
DATE		зтит
06.09.25		WEB

AEROSPACE I

LTD

SHEET

2 OF 2

<u>;;</u>

#### R0.35 (TYP) 1.629 3.012 /E' (1.506 PITCH) **#0.172 (4 HOLES)** R0.13 4.283 4.800 0.500 -GRAIN 6.400 2.692 DIRECTION 0 0.900 0.821 Ø0.128 (22 HOLES) - 0.300 -1.375 1.075 10.500 (1.050 PITCH) 0.550 11.550 (1.050 PITCH)

85°

### D2174-1

### NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6.250

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES



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